

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014112**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Lift 4 North Tower pad eye on skin E. The weld designations reviewed are as follows.

NSD1-FESA4-3A/F- 38,39,40,41

NDT Notification No: 004994

BAY 10

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% and randomly Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as North Tower Interior splice plate on skin D. The weld designations reviewed are as follows.

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NSD1-SPSA4-20-1~ 4A/B
NDT Notification No: 005000

BAY 12

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Traveler Bracket. The weld designations reviewed are as follows.

19TB2-001-002,19TB3-001-002,
14TB6-001-002,14TB2-001-002
14TB9-002-002, 14TB10-001-002,
15TB5-001-002, 15TB12-001-002,
16TB6-001-002, 16TB10-001-002,
17TB9-001-002,17TB11-001-002,
NDT Notification No: 004996

This QA Inspector observed the following work in progress:

BAY 11

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 049099 perform Shielded Metal Arc Welding (SMAW) on West Tower Lift 4 C/D corner joint. Joint identified as WSTL4-2B/L-57A/B. ZPMC QC Identified as Xu Jinlong with Welding Repair Report no-WRR#T-WR2950. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair.

BAY 10

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040582 perform Shielded Metal Arc Welding (SMAW) on Strut Plate. Joint identified as ED1-STSA3-2-89M-2-64. ZPMC CWI Identified as Chen Ying Xin, with Critical Welding Repair Report no-CWR#T-CWR526. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-1G(1F)FCM Repair-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
